

Work Order ID 60455

Friday, July 09, 2010 9:53:57 AM



Page 1

Item ID: D3762-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Front Leg Fitting Assembly

Start Date: 7/12/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 10-7-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3762

Rev A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EL 10-8-4

110

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-assemble as per dwg D3762 using locating pins DT9014 and tack weld parts in place
2- take pins out before welding
3-weld as per dwg D3762 per QSI004
Alum. rod Batch: M 114242

EL 10-8-4

(18)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

8 0 BE 10/08/05

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Suloslos

78

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

J

10/08/05

48 0

W/O:			WORK ORDER CHANGES					
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Page 3

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Item Name: Front Leg Fitting Assembly

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Start Date: 7/12/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 10-8-5

160

Identify as per dwg & Stock Location 251

0.00



Packaging

Memo

0.00

Packaging

10/8/6 SP (8K)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/09 ME 10-8-06

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, July 09, 2010 9:53:56 AM

Page 1

Work Order ID: 60455



Parent Item: D3762-041



Parent Item Name: Front Leg Fitting Assembly

Start Date: 7/12/2010

Required Date: 7/16/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3762-1 Fitting		Manufactured	No			110	Each	5.0000	2	16			
	60796 x 11												
				<u>Location</u>									
				ST250A				5					
				56754				5					
D3762-3 Tube		Manufactured	No			100	Each	2.0000	1	8			
				<u>Location</u>									
				ST251				2					
				56753				2					
	60797							6					



EL 10-8-4



EL 10-8-4

2
6

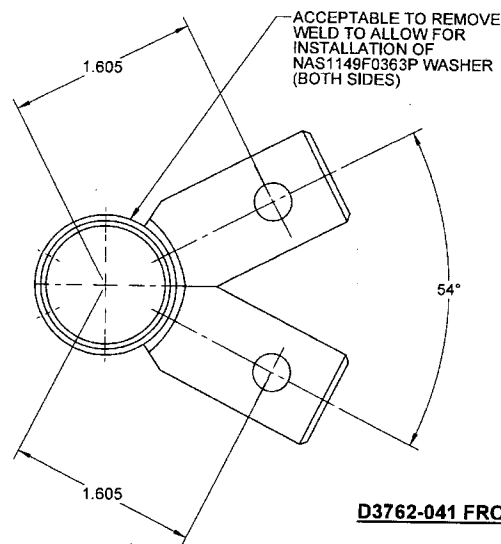
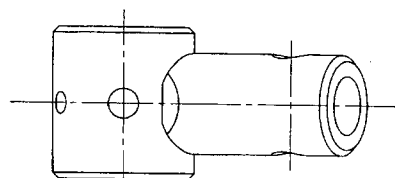
W/O:			WORK ORDER CHANGES					
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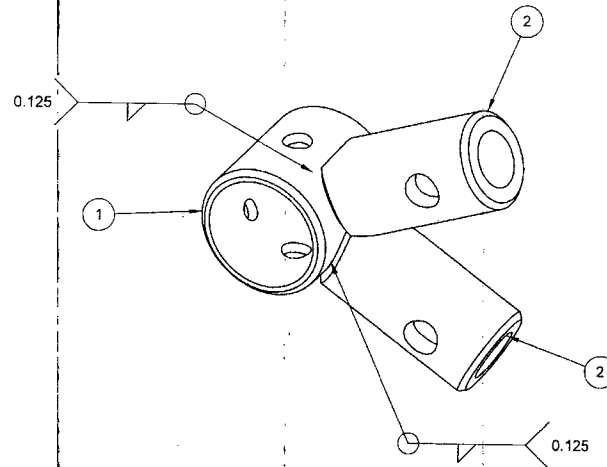
NOTE: Date & initial all entries



ACCEPTABLE TO REMOVE
WELD TO ALLOW FOR
INSTALLATION OF
NAS1149F0363P WASHER
(BOTH SIDES)

D3762-041 FRONT LEG FITTING ASSY

60455



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3762-3	TUBE	1
2	D3762-1	FITTING	2

RELEASED
08-06-16

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs
 - 8) WELD: PER DART QSI 004

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS	DRAWING NO.	REV. A
CHECKED	HS	D3762	SHEET 1 OF 3
MFG. APPR.	HS	TITLE	SCALE
APPROVED	HS	FRONT LEG FITTING	NTS
DE APPR.	HS	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.06.04		

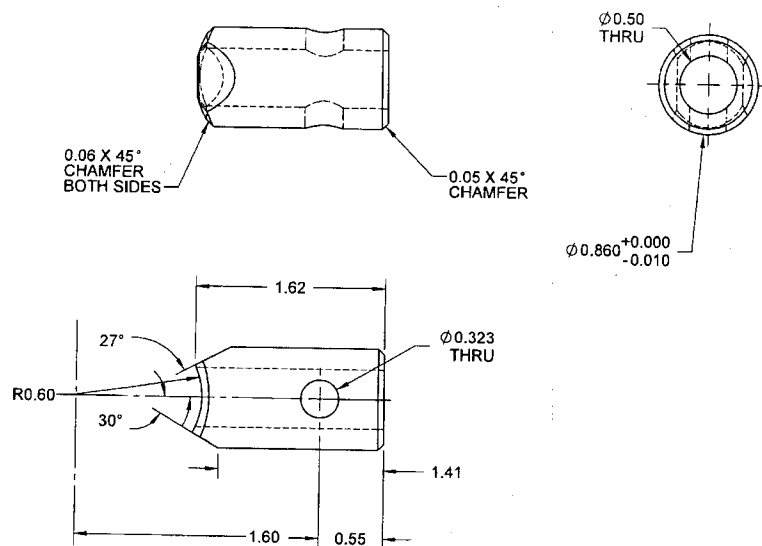
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

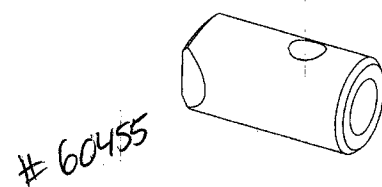


D3762-1 FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC. M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Ref</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JAD</i>	D3762	SHEET 2 OF 3
APPROVED	<i>JAD</i>	TITLE	SCALE
DE APPR.	<i>JAD</i>	FRONT LEG FITTING	NTS
DATE	08.06.04	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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RELEASED
08-06-04

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

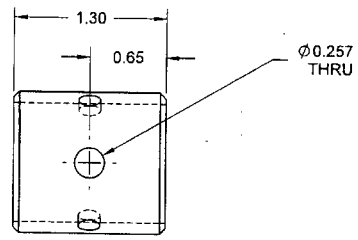
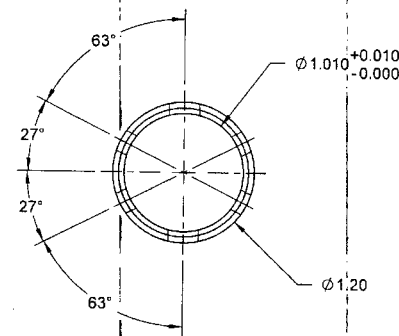
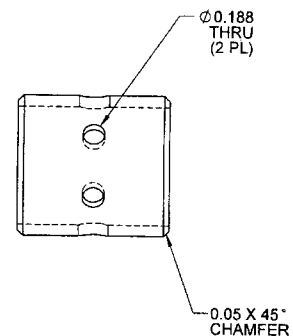
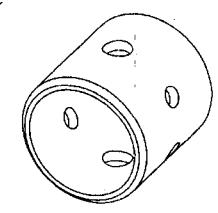
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NOTE: Date & initial all entries

#60455



D3762-3 TUBE

RELEASED
08-06-16/10

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	AP	D3762	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	FRONT LEG FITTING	NTS
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